

User:

Monday, 20/04/2009 10:12:42 AM

Jean-Luc Menard

Process Sheet

: CU-DAR001 Dart Helicopters Services Customer

Job Number : 47280 - /

: 12401 Estimate Number

P.O. Number

This Issue : 20/04/2009

Prsht Rev. : NC

First Issue : 20/04/2009 : 28705

Previous Run Written By

Checked & Approved By

Comment

: Est

A

Type

S.O. No. :

06.05.03 New issue

: MACHINED PARTS

Drawing Revision Material

Description:

Due Date

Drawing Name

Part Number

Drawing Number

Project Number

: 27/04/2009

: CAP

: D31839

· D3183

: NA

; C1

Qty:

Each

Additional Product

Job Number:

Seq. #: 1.0 MDELRINR1000

Machine Or Operation:

Delrin Round Bar 1"

Comment: Qty.:

0.0350 f(s)/Unit Total:

1.7483 f(s) X

Delrin Round Bar 1"

Material: Ø1.00 Delrin Rod (M-DELRIN-R1.000)

Identify as D3183-9

Batch: 410880

HARDINGE 20

HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

Turn D3183-9 Cap as per Folio FA388

Deburn

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

Comment: SECOND CHECK

5.0 PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PACKAGING RESOURCE #1

SECOND CHECK

09.04.

A-			

Date: User: Monday, 20/04/2009 10:12:42 AM

- Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 47280

Part Number: D31839

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



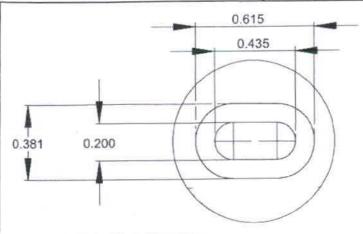
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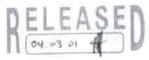


DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	D3183	REV. C SHEET 4 OF 4
DATE 04	.02.17	BRACKET ASSEMBLY	SCALE 1:1

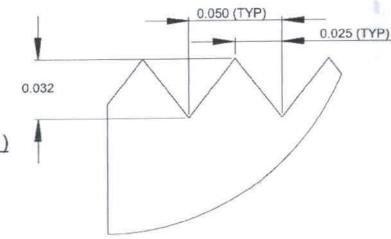


DETAIL A (2:1)

w/0 47250



DETAIL B (20:1)



0.276 0.199 ± 0.001 0.039 R0.031 0.720 -0.850 ± 0.002 0.747 0,830 ±0.001 R0.010 SECTION C-C SCALE 2:1

D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00) 2) TOLERANCES ARE PER DART QSI 018
- UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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DART AEROSPACE LTD	Work Order:	47280
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.830	+/-0.005	,827				
Ø0.720	+/-0.002	,827				
Ø0.747	+/-0.001	. 747				
R0.010	+/-0.010	1.005				
R0.031	+/-0.010	1.025				
0.199	+/-0.001	-198				
0.276	+/-0.010	-277				
0.039	+/-0.010	,0385				
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2/)		/ / //			
Measured by:		Audited by:		Prototype Approval:	N/A	
Date: 07 /	04/20	Date:	09.01.20	Date:	N/A	

Rev	Date	Change	Revised by Approved
	04.04.20	New Issue (P/O D3183-045)	KJ/RF
	The second second second second	Dimension Ø0.830 was Ø0.850	KJ/JLM A